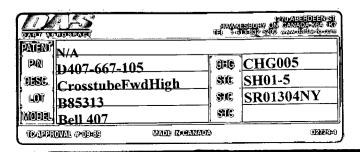
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Item ID: Revision ID: Item Name:	D407-667-1 Crosstube Fw		Accept *N900040100* Setup Star							I VI .	S1* S2*	
Start Date: Required Date: Reference:	8/17/2012 : 8/24/2012 NCR 12-169	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:						
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Ī	Torque Waves in Extrusion					Drawing		Out of 0	Calibration				
	Turning Sequence					Finish		Out of Sequence					

Outside Dimensions

Date:

DQA:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Quality Control

Friday, August				*890	120*							Page
Item ID: Revision ID:	D407-667-1	05		*N900040100*)*	Setup	Start	*N	S1*
Item Name:	Crosstube Fw	vd								Stop	*NI	S2*
Start Date:	8/17/2012	Start Qty: 1.00	*1*		Cust Item 1	D:					1 4	. 17
Required Date:	8/24/2012	Req'd Qty: 1.00	*1*		Customer:							
Reference:	NCR 12-169	95	•									
Approvals:	Process Pla	an:	Date:	Tooling:	D:	ate:]	Run Start *NR		R1*	
	QC:		Date:	SPC (Y/N):	D:	ate:				Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
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Packaging		Memo ID AND ST	OCK UNDER NEW BAT	0.00 TCH NUMBER AT CHG I	NUMBER 005							/ 、
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NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
										·	QA Closed:	Date	· ·	
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Part No						Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab			Crosstube Small Fab Finishing Composite	ł	Water Jet Engineering d. Eng. Coor. Quality re/Packaging Other Supplier		
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	Ripples in Bend					Drill Holes		Offset						
	Ш	Torque W	aves in E	xtrusion		Drawing		Out of C	Calibration					
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	<u></u>	Wave/Twi	<u>ist i</u> n Tub	e		Folio		Outside Dimensions						

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART SERVICE INSTRUCTION TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. D AND EARLIER AND

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. D AND EARLIER AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 3 AND EARLIER

REF: CANADIAN STC: SH01-5 REF: FAA STC: SR01304NY REF: EASA STC: EASA.IM.R.S.01179

PURPOSE:

The purpose of this service instruction is to permanently add the D206-667-017 Kit to the DXXX-667-101/-103/-105/-107 Crosstube kits.

INSTRUCTIONS:

DXXX-667-101/-103/-105/-107 Crosstubes at CHG 005/006/005/003 (respectively) and later are supplied with the D206-667-017 Grounding Strap Kit installed per section 3.2 of IIN-D206-667 Rev. D.

WEIGHT AND BALANCE

There is a negligible weight change associated with the installation of this kit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

BY: D. SHEPHERD (DE # 02)

DATE: 12.08.02
CERT. NO.: SH01-5
ISSUE NO.: 3

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DE APF	PR.	4		GROUNDING STRAP INS	TION NTS						
DATE	12.0	8.02		COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMARKCHED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD							

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Outside Dimensions

DQA: Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C AND EARLIER AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2 AND EARLIER

REF: CANADIAN STC: SH01-5 REF: FAA STC: SR01304NY REF: EASA STC: EASA.IM.R.S.01179

PURPOSE

The purpose of this service instruction is to add the optional D206-667-017 Kit and provide guidelines to install extra clamps on D206-667-101/-103 or D407-667-105 forward crosstubes to allow fastening of OEM grounding straps.

INSTRUCTIONS:

- 1) If installed, follow Section 32.1 of ICA-D206-667 for removal of the forward crosstube from the helicopter.
 2) Locate AN742D36 Clamp as shown in Figure 1 of this service instruction and mark location of clamp on the crosstube.
- 3) Remove crosstube finish (paint and primer) in area where AN742D36 Clamp will be installed and touch up
- affected area with chemical film material (Alodine 1200 or 1201) per MiL-C-5541.

 4) Install AN742D36 Clamp complete with MS9165-05 per Section A-A of Figure 1 of this service instruction.

 5) Touch up paint as required per Item 5.3.3 of ICA-D206-667.

 6) Seal edges where AN742D36 Clamp meets with crosstube using Sikaflex-241/291 or MIL-S-8802 Class B2 or Proseal 890 sealant.
- 7) Install/re-install forward crosstube in accordance with Section 32.2 of ICA-D206-667.
- 8) Fasten OEM grounding strap to MS9165-05 Angle Bracket on forward crosstube per Bell instructions.
 9) Undertake a resistance check between a ground point on the skidtube and aircraft ground in accordance with Class R-II requirement per BHT-ELEC-SPM. Maximum resistance is 10 milliohms (mΩ).

PARTS LIST:

QTY -017	PART NUMBER	DESCRIPTION						
X	D206-667-017	GROUNDING STRAP INSTALLATION						
2	AN742D36	CLAMP						
2	MS9165-05	ANGLE BRACKET						
2	MS21042-3	NUT						
2	MS27039-1-08	SCREW						
4	NAS1149C0332R	WASHER						

WEIGHT AND BALANCE

CANADA

There is a negligible weight change associated with the installation of this kit.

AIRCRAFT BI	T OF TRANSPORT CERTIFICATION RANCH # 01-0-01
BY:	PROVED .
D, SHEPH	IERD (DE # 02)
DATE:	11.02.25
CERT. NO.:	SH01-5
ISSUE NO.:	3

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DATE 11.02.18				COPYRIGHT @ 2011 BY DART AEROSPACE LTD THIS DOCUMENTS PRIVATE AND CONFIDENTIAL AND IS SUPPLED ON THE SUPPLES CONCIDENTIAL THIS NOTTO BE USED FOR ANY PURPLES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WANTEN PER					

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Grain

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Over/Under tolerance

Pressure/Forced

Weld

Other

Temperature/Cure

Wrong Stock Pulled

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

Bend

Burrs

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Broken/Damaged

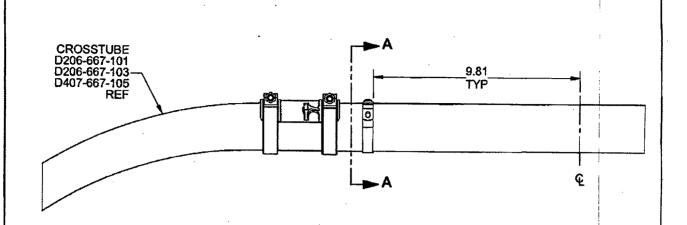
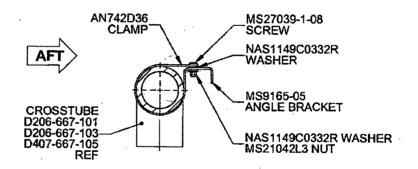


FIGURE 1 - GROUNDING STRAP INSTALLATION (VIEW LOOKING FWD)



SECTION A-A

(SUPPORT, CLAMP, CUSHION NOT SHOWN FOR CLARITY)
TYP, 2 PL PER CROSSTUBE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

BY: D. SHEPHERD (DE # 02)

DATE: 11
CERT. NO.: SH

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DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA DRAWING NO.

DSI 9544

REV. A SHEET 2 OF 2

TITLE

GROUNDING STRAP INSTALLATION NTS

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Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence
Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio